

Work Order ID 83074

83074

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April-12-12 4:09:03 PM

Item ID: D2013-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mirror Bracket LH, 212
 Start Date: 12/04/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 26/04/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2013	Rev C

100 0.00
100 NC BRAKE
 Brake NC
 Brake NC
 Memo 0.00
 1-Punch as per template D2013-T3 and Dwg D2013 → SB 12/05/10
 2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545
 3-Bend (1) tube as per Dwg D2013 using Jig DT8201
 Identify as D2013-3.
 4-Deburr as required

110 0.00
110 QC5- Inspect part completeness to step on W/O
 QC 0.00
 Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <i>W/A</i>	0.00							
120									
Packaging	Memo	0.00				<i>6</i>		<i>12-5-23</i>	
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/5/25
MF
12-05-23

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 83074

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Parent Item: D2013-3

D2013-3

Parent Item Name: Mirror Bracket LH, 212

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	306.2570	1.9473	12.29874			

M304TR0 750W 049

304 RD Tube .750 x .049W

**

Sp 12/25/12

Location

Loc Qty

Loc Code

MAT017

306.257

109314

9.333

111619

3

112187

4

112800

11

114852

2.75

116108

3

117797

0.75

120441

37.534

121170

234.89

121666

15

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

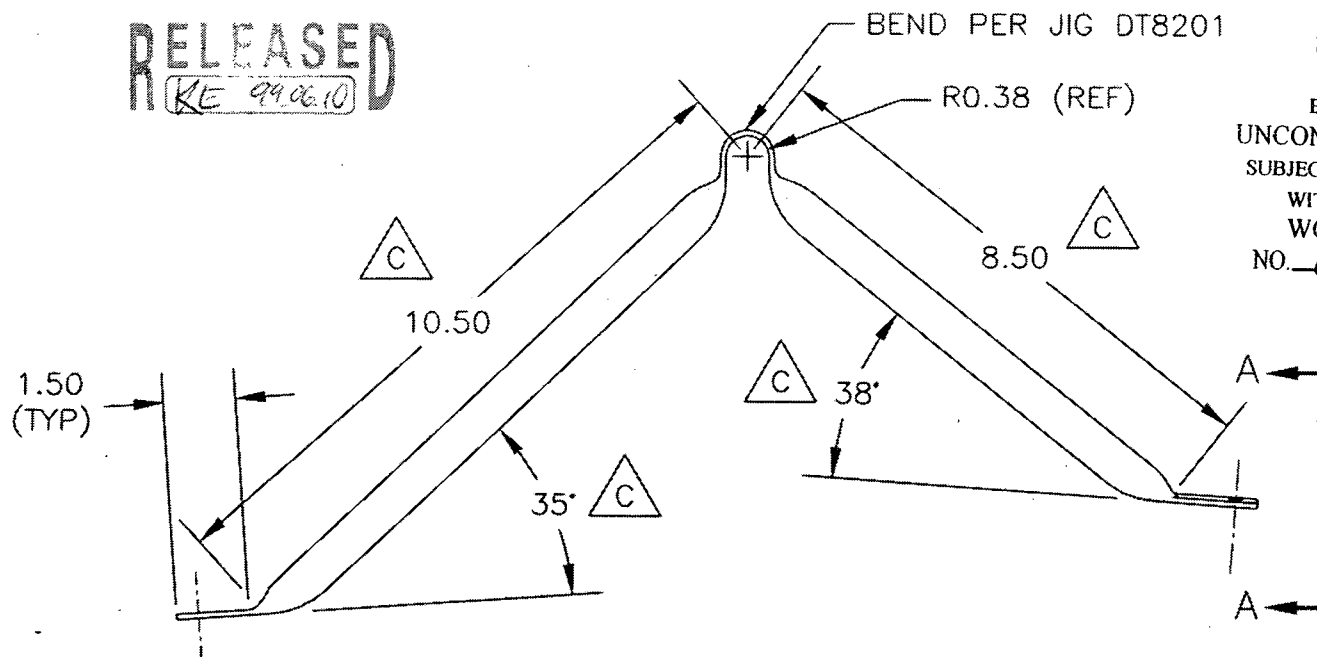
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

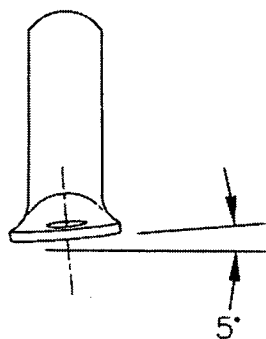
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NOTE: Date & initial all entries

RELEASED
KE 99.06.10



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



VIEW A-A

DRILL $\phi 0.257$ (TYP)

0.400 (TYP)

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83074 MLJ

12/04/13

DART



DESIGN	JB	DRAWN BY	DATE	CHECKED	APPROVED	DRAWING NO.	TITLE	REV. C	SHEET 1 OF 3
		RF	99.06.07	KE		D2013	MIRROR BRACKET		
A			90.10.22				NEW ISSUE		
B			94.06.15				REDRAWN		
C			99.06.07				REDRAWN, CHANGE OF DIMENSIONS		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

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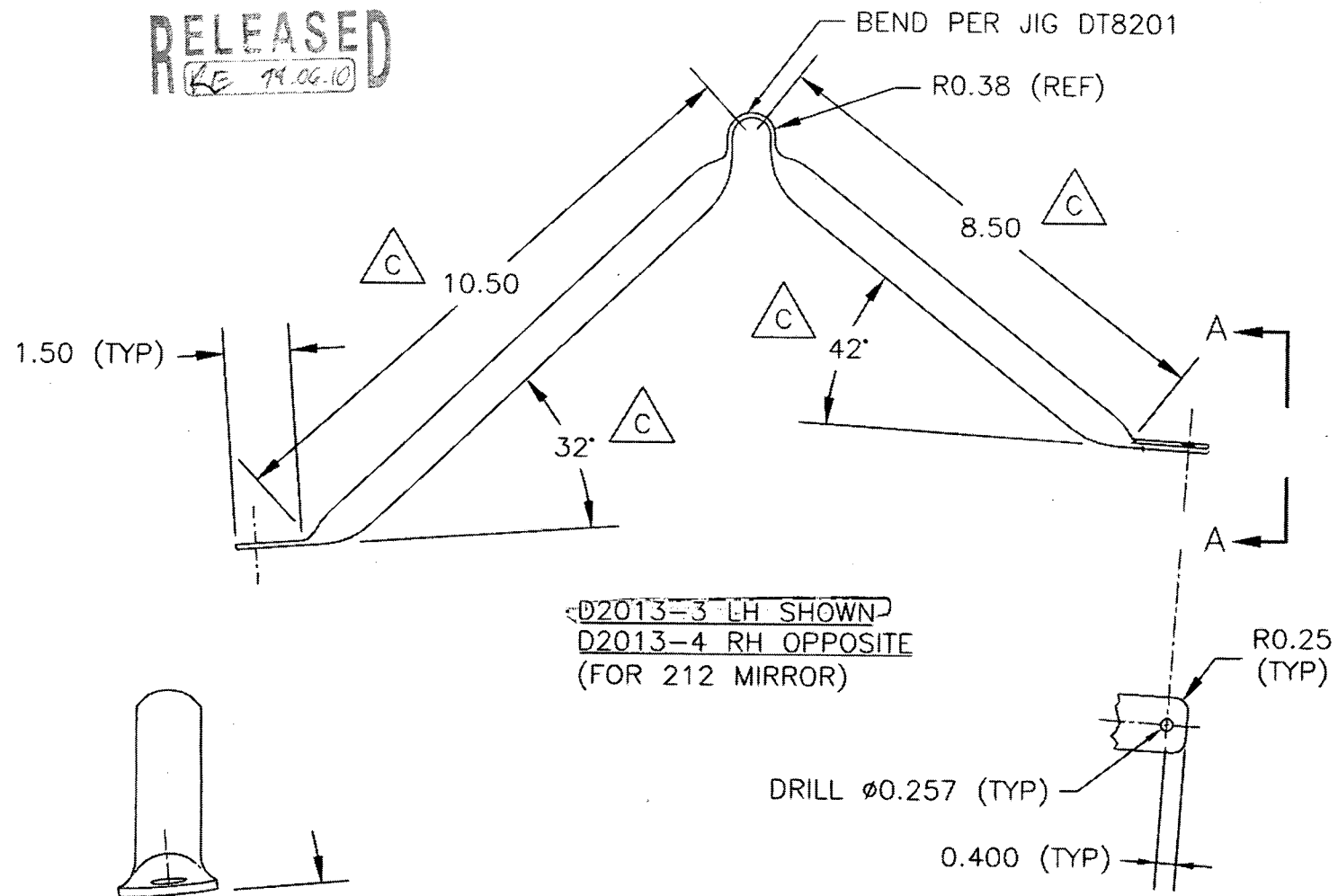
NOTE: Date & initial all entries

83074

RELEASED
RE 14.06.10

DART

QA COPY ISSUED



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	KE	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	99.06.07	DRAWING NO.	D2013	REV. C
		TITLE	MIRROR BRACKET	SHEET 2 OF 3
				SCALE
				NTS

Copyright 1990 by DART AEROSPACE LTD

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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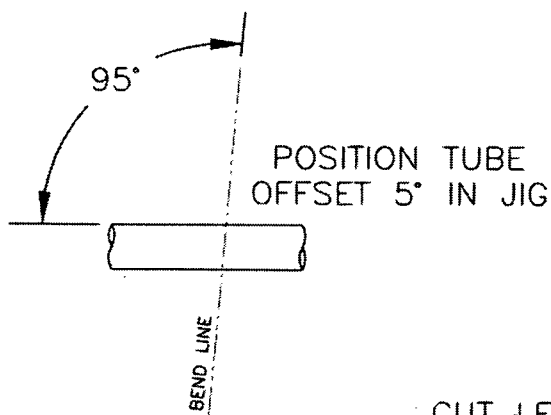
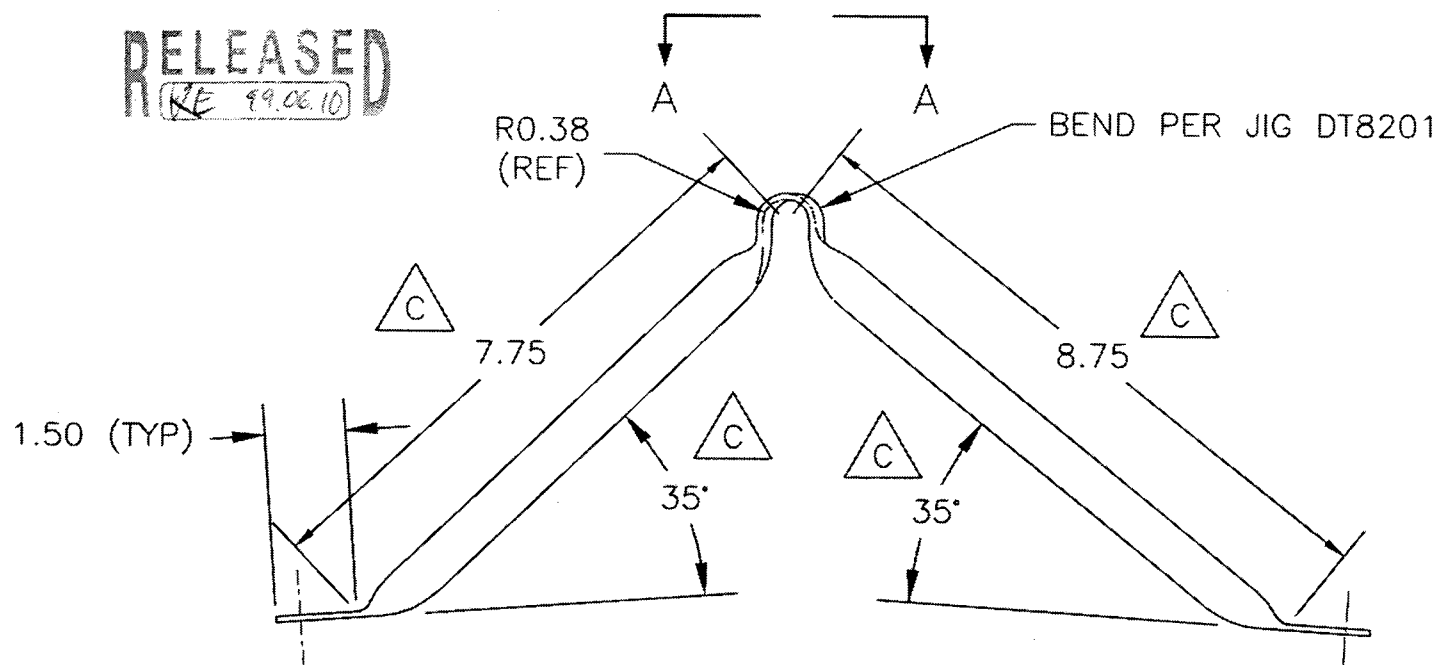
NOTE: Date & initial all entries

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RELEASED
KE 99.06.10

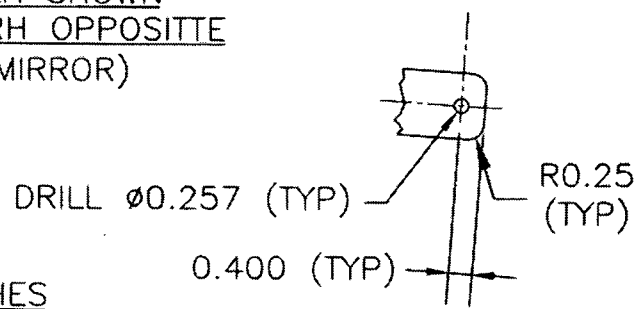
DART

ISSUED
COPY



POSITION TUBE
OFFSET 5° IN JIG

D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DESIGN	JB	DRAWN BY	RM	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 3 OF 3
		SCALE	NTS	

W/O:		WORK ORDER CHANGES						
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